JET®

Operating Instructions and Parts Manual

Shear, Brake and Roll Machines

Models SBR-30M, SBR-40M



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Part No. M-756031
Revision A 08/2011

1.0 **Warranty and Service**

Walter Meier (Manufacturing) Inc., warrants every product it sells. If one of our tools needs service or repair, one of our Authorized Service Centers located throughout the United States can give you quick service. In most cases, any of these Walter Meier Authorized Service Centers can authorize warranty repair, assist you in obtaining parts, or perform routine maintenance and major repair on your JET® tools. For the name of an Authorized Service Center in your area call 1-800-274-6848.

MORE INFORMATION

Walter Meier is consistently adding new products to the line. For complete, up-to-date product information, check with your local Walter Meier distributor, or visit waltermeier.com.

WARRANTY

JET products carry a limited warranty which varies in duration based upon the product (MW = Metalworking, WW = Woodworking).

90 DAY WARRANTY	1 YEAR WARRANTY	2 YEAR WARRANTY	3 YEAR WARRANTY	5 YEAR WARRANTY	LIFETIME WARRANTY
Lathe Accessories Machine Accessories Mobile Bases Safety Equipment Specialty Items Vise Accessories	Air Tools-Contractor Air Tools-Industrial Air Tools-Light Industrial Lubrication	Body Repair Kits Bottle Jacks Cable Pullers Cold Saws Hoists-Air Hoists-Electric Metal forming Mill/Drills Milling Machines MW Bandsaws MW Drill Presses MW Finishing Equipment MW Lathes MW Precision Vises Palet Trucks Rigging Equip. Service Jacks Stackers Surface Grinders Tapping Trolleys-Air Trolleys-Electric Web Slings Winches-Electric	WW Benchtop Tools	Beam Clamps Chain Hoist-Manual Lever Hoists Pullers-JCH Models Scissor Lift Tables Screw Jacks Trolleys-Geared Trolleys-Plain Winches-Manual WW Air Filtration WW Bandsaws WW Buffers WW Drill Presses WW Dust Collectors WW Dust Filters WW Dust Fittings WW Jointers WW Lathes WW Planers WW Sanders WW Shapers WW Tablesaws	Fastening Tools Mechanics Hand Tools Striking Tools Vises (no -precision) Clamps

Warranty reverts to 1 Year Warranty if woodworking (WW) products listed above are used for industrial or educational purposes.

WHAT IS COVERED?

This warranty covers any defects in workmanship or materials subject to the exceptions stated below. Cutting tools, abrasives and other consumables are excluded from warranty coverage.

WHO IS COVERED?

This warranty covers only the initial purchaser of the product.

WHAT IS THE PERIOD OF COVERAGE?

The general JET warranty lasts for the time period specified in the product literature of each product.

WHAT IS NOT COVERED?

Five Year Warranties do not cover woodworking (WW) products used for commercial, industrial or educational purposes. Woodworking products with Five Year Warranties that are used for commercial, industrial or education purposes revert to a One Year Warranty. This warranty does not cover defects due directly or indirectly to misuse, abuse, negligence or accidents, normal wear-and-tear, improper repair or alterations, or lack of maintenance.

HOW TO GET SERVICE

The product or part must be returned for examination, postage prepaid, to a location designated by us. For the name of the location nearest you, please call 1-800-274-6848.

You must provide proof of initial purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, we will repair or replace the product, or refund the purchase price, at our option. We will return the repaired product or replacement at our expense unless it is determined by us that there is no defect, or that the defect resulted from causes not within the scope of our warranty in which case we will, at your direction, dispose of or return the product. In the event you choose to have the product returned, you will be responsible for the shipping and handling costs of the return.

HOW STATE LAW APPLIES

This warranty gives you specific legal rights; you may also have other rights which vary from state to state.

LIMITATIONS ON THIS WARRANTY

WALTER MEIER (MANUFACTURING) INC., LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD OF THE LIMITED WARRANTY FOR EACH PRODUCT. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MERCHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU.

WALTER MEIER SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERTY, OR FOR INCIDENTAL, CONTINGENT, SPECIAL, OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU.

Walter Meier sells through distributors only. The specifications in Walter Meier catalogs are given as general information and are not binding. Members of Walter Meier reserve the right to effect at any time, without prior notice, those alterations to parts, fittings, and accessory equipment which they may deem necessary for any reason whatsoever. JET® branded products are not sold in Canada by Walter Meier.

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3.0 **Safety Warnings**

1. Read and understand entire owner's manual before attempting assembly or operation.
2. Read and understand the warnings posted on the machine and in this manual. Failure to comply with all of these warnings may cause serious injury.
3. Replace warning labels if they become obscured or removed.
4. This shear/brake/roll machine is designed and intended for use by properly trained and experienced personnel only. If you are not familiar with the proper and safe operation of a shear/brake/roll, do not use until proper training and knowledge have been obtained.
5. Do not use this machine for other than its intended use. If used for other purposes, Walter Meier (Manufacturing), Inc., disclaims any real or implied warranty and holds itself harmless from any injury that may result from that use.
6. This shear, brake and roll is intended to be used by one person only. Keep others away from the machine during operations.
7. The shear, brake and roll must be bolted securely to a stand and the stand bolted securely to the floor. If the machine is to be bench-mounted, the bench must be able to support the weight of the machine and must be bolted to the floor.
8. Always wear approved safety glasses/face shields while using this machine. *Everyday eyeglasses only have impact resistant lenses; they are not safety glasses.*
9. Keep the floor around the shear, brake and roll clear of scraps, debris, oil and grease. The flooring around the machine should be a non-skid type.
10. Sheet metal stock has sharp edges. To prevent cuts, deburr edges and use gloves when handling.
11. Keep top guard in place when not using the slip roll.
12. Keep hands and fingers clear of the slip roll pinch points.
13. Keep hands and fingers away from the area in front and rear of the shear blades.
14. Keep hands and fingers away from the press brake dies.
15. Do not exceed the maximum capacity of the machine.
16. Do not use the shear to cut round bars, chain, steel cable or hardened metals.
17. Before operating this machine, remove tie, rings, watches and other jewelry, and roll sleeves up past the elbows. Remove all loose clothing and confine long hair.
18. Some dust created by power sanding, sawing, grinding, drilling and other construction activities contains chemicals known to cause cancer, birth defects or other reproductive harm. Some examples of these chemicals are:
    - Lead from lead based paint.
    - Crystalline silica from bricks, cement and other masonry products.
    - Arsenic and chromium from chemically treated lumber.

    Your risk of exposure varies, depending on how often you do this type of work. To reduce your exposure to these chemicals, work in a well-ventilated area and work with approved safety equipment, such as face or dust masks that are specifically designed to filter out microscopic particles.
19. Do not operate this machine while tired or under the influence of drugs, alcohol or any medication.
20. Check damaged parts. Before further use of the machine, a guard or other part that is damaged should be carefully checked to determine that it will operate properly and perform its intended function. Check for alignment or binding of moving parts, breakage of parts, mounting and any other conditions that may affect its operation. A guard or other part that is damaged should be properly repaired or replaced.
21. Provide for adequate space surrounding work area and non-glare, overhead lighting.
22. Give your work undivided attention. Looking around, carrying on a conversation and "horse-play" are careless acts that can result in serious injury.

Familiarize yourself with the following safety notices used in this manual.

⚠CAUTION This means that if precautions are not heeded, it may result in minor injury and/or possible machine damage.

⚠WARNING This means that if precautions are not heeded, it may result in serious or even fatal injury.

4.0 **About this manual**

This manual is provided by Walter Meier (Manufacturing) Inc. covering the safe operation and maintenance procedures for a JET model SBR-30M and SBR-40M Shear, Brake and Roll. This manual contains instructions on installation, safety precautions, general operating procedures, maintenance instructions and parts breakdown. Your machine has been designed and constructed to provide years of trouble-free operation if used in accordance with the instructions as set forth in this document.

If there are questions or comments, please contact your local supplier or Walter Meier. Walter Meier can also be reached at our web site: www.waltermeier.com.

Retain this manual for future reference. If the machine transfers ownership, the manual should accompany it.

⚠WARNING **Read and understand the entire contents of this manual before attempting set-up or operation. Failure to comply may cause serious injury.**

5.0 **Specifications**

	SBR-30M	SBR-40M
Model Number	**SBR-30M**	**SBR-40M**
Stock Number	756031	756041
Materials:		
Frame	cast iron	cast iron
Table	cast iron	cast iron
Handles	steel	steel
Rolls	steel	steel
Capacities & Dimensions:		
Capacity - mild steel	20 ga.	20 ga.
Footprint (LxW)	32-1/2"x14-1/2" (826x368mm)	43"x18" (1096x457mm)
Dimensions, assembled (LxWxH)	44"x14"x24" (1118x356x610mm)	54"x18"x27-1/2"(1372x457x699mm)
Shearing:		
Shearing capacity	20 ga. x 30" (762mm)	20 ga. x 40" (1016mm)
Shear blade	reversible	reversible
Bending:		
Bending capacity	20 ga. x 30" (762mm)	20 ga. x 40" (1016mm)
No. of male dies	7	8
No. of female dies	1	1
Width of upper dies	1, 2, 3, 4, 4, 6, 10"	1, 2, 2, 4, 6, 7, 8, 12"
Upper die height	4-3/4" (121mm)	4-3/4" (121mm)
Rolling:		
Rolling capacity	20 ga. x 30" (762mm)	20 ga. x 40" (1016mm)
Wire grooves (dia.)	1/8", 3/16", 1/4"	1/8", 3/16", 1/4"
Size of slip rolls (dia. x L)	1-1/2" x 30" (38x762mm)	1-5/8" x 40" (41x1016mm)
Minimum forming radius	3/4" (19mm)	1" (25.4mm)
Weights:		
Net	286 lb. (130 kg)	506 lb. (230 kg)
Shipping	332 lb. (151 kg)	561 lb. (255 kg)

The specifications in this manual were current at time of publication, but because of our policy of continuous improvement, Walter Meier (Manufacturing) Inc., reserves the right to change specifications at any time and without prior notice, without incurring obligations.

6.0 **Set-Up and Assembly**

6.1 **Floor Diagrams**

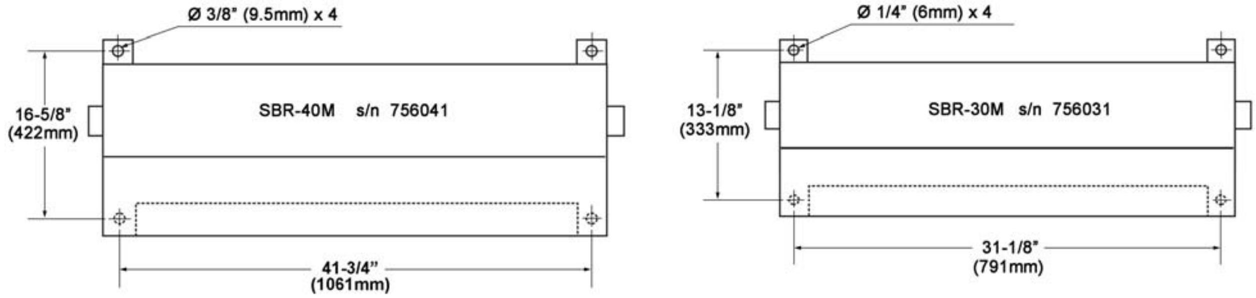


Figure 1 – hole centers for Shear, Brake and Roll

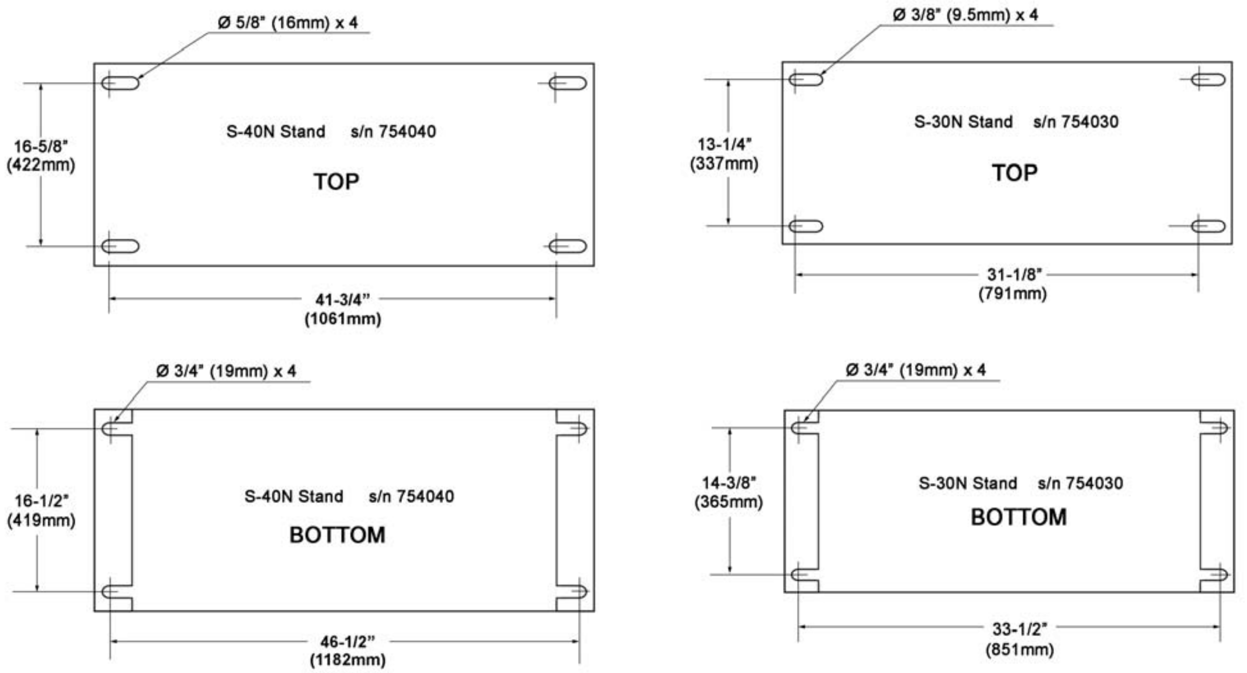


Figure 2 – hole centers for Stands (OPTIONAL)

6.2 **Unpacking**

Open shipping container and check for shipping damage. Report any damage immediately to your distributor and shipping agent. Do not discard any shipping material until the Shear/Brake/Roll machine is assembled and running properly.

Compare the contents of your container with the following parts list to make sure all parts are intact. Missing parts, if any, should be reported to your distributor. Read the instruction manual thoroughly for assembly, maintenance and safety instructions.

Contents of Shipping Container

1 Shear, Brake and Roll machine
2 Handle assemblies
2 Guide rods with hex nuts
1 Guide plate
2 Mounting Blocks with T-handles
1 Instructions and Parts Manual
1 Warranty Card

6.3 **Assembly**

Tools required for setup and assembly:

5, 6, 8mm hex keys (“Allen wrenches”)

19mm open end wrench

1. Finish removing crate from around machine.
2. Remove bolts holding machine to pallet.
3. Carefully clean all rust protected surfaces with a mild solvent or kerosene and a soft rag. Do not use lacquer thinner, paint thinner, or gasoline, as these may damage painted surfaces.
4. Coat all machined surfaces with a very light film of oil to inhibit rust.
5. Carefully move machine to a work bench or stand. Machine location must allow free access on all sides.
6. Bolt machine to stand or workbench. The stand or workbench must be bolted to the floor.

   (NOTE: An optional stand is available for this machine; see Section 9. Contact your JET distributor to order.)
7. Remove one handle (A, Figure 3) from each operating handle assembly, using 8mm hex key.

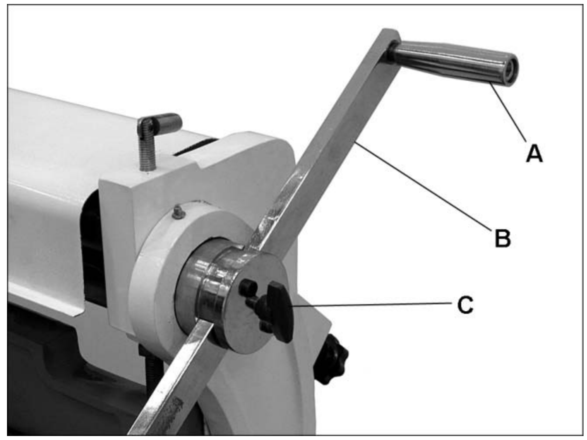


Figure 3

8. Loosen lock bolt (C, Figure 3).
9. Slide bar (B) into hub and tighten lock bolt (C) to secure.
10. Re-install handle (A).
11. Install both *guide rods* into either the upper or lower set of threaded holes (Figures 4/5) and tighten the setting by rotating *hex nut* against the cast base of the machine with 19mm wrench.

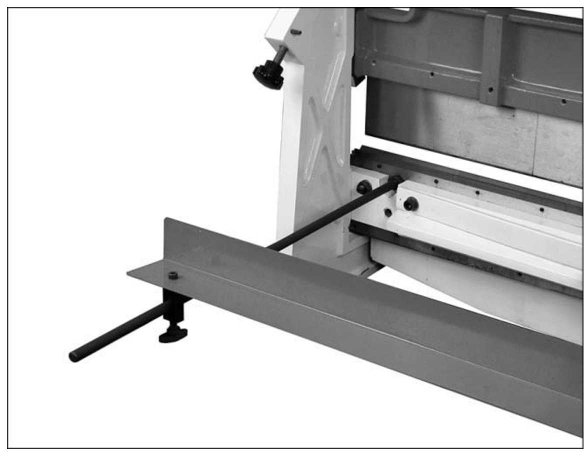


Figure 4
(Brake position)

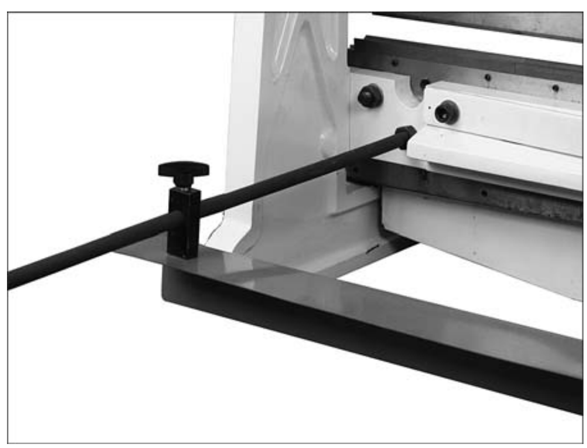


Figure 5
(Shear position)

NOTE: For brake operation, install guide rods into upper set of holes (Figure 4); for shear operation, install in lower set of holes (Figure 5).

12. Install *guide plate* as shown in Figures 4 or 5. Secure it to rods using the T-handles.

6.4 Press Brake set-up

⚠WARNING Do not bend material larger than 30” (40”) 20-gauge mild steel. Failure to comply may cause serious injury and/or damage to the machine.

To set up for bending:

1. Place a strip of wood (D, Figure 6) on bottom die, the full length of die.
2. Close brake until the wood contacts upper dies (E).
3. Loosen screws (F) using 6mm hex key.

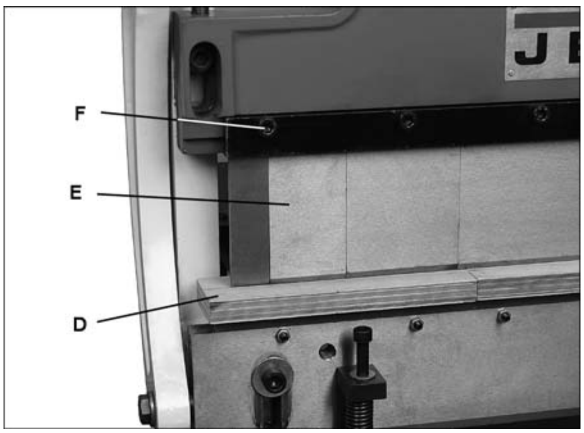


Figure 6

4. Select upper dies (E) for desired job and remove the others by sliding them out the left end.
5. Move operating handle until the wood pushes up the dies so that they seat uniformly in upper beam.
6. Securely re-tighten all screws (Figure 4), then release and remove wood strip.
7. If making repeated bends or using a long workpiece, position guide rods and plate for brake operation, as shown in Figure 4.
8. Scribe a line on workpiece for bend location. (Be sure to accommodate bend allowance based upon thickness of material. This can be done either through trial and error, or by consulting a machinist’s handbook.)
9. Rest workpiece on v-block (lower die) so that the scribed line is aligned with the tips of upper die(s).
10. Hold workpiece steady and use operating handle to make bend.

To adjust brake beam (G, Figure 7) for 90° bends at bottom of stroke:

1. Slightly loosen locking screws (H) using 8mm hex key.
2. Turn brake beam adjusting screws (J) with 19mm wrench, until test bends reflect 90° bend at both ends of brake.
3. Re-tighten screws (H).

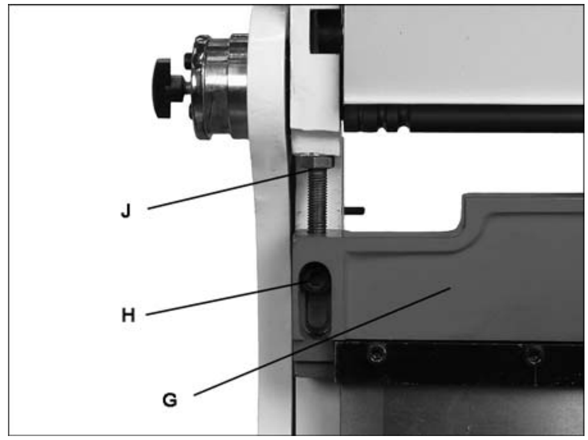


Figure 7

For special repetitive bends, the brake beam may be adjusted to over-bend the desired angle since the metal will have some degree of “spring back”.

6.5 Shear set-up

⚠WARNING Do not shear material larger than 30” (40”) 20 gauge mild steel. Failure to comply may cause serious injury and/or damage to the machine.

1. Install guide rods and plate in shear position (Figure 5) and adjust to desired length of workpiece cut.
2. Place workpiece against guide block at right edge of table (K, Figure 8). The end of workpiece should be against guide plate.
3. Operate handle to begin shearing cut. Shearing action progresses from right to left.

NOTE: To prevent distortion when notching, “snap” the handle to facilitate piercing.

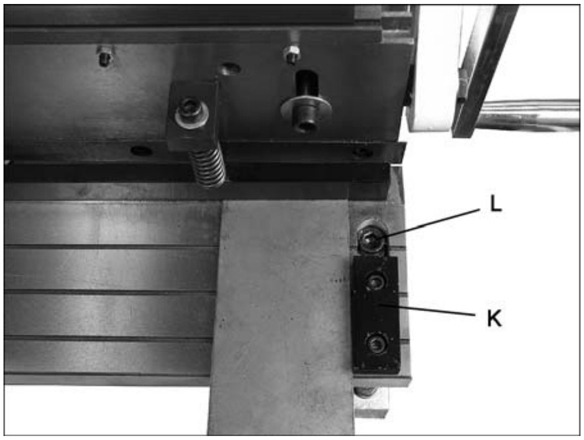


Figure 8

6.5.1 **Lower Blade Adjustment**

Upper and lower shear blades have been factory aligned and should not require immediate adjustment. Should re-alignment be needed in the future, proceed as follows:

1. Place a heavy sheet of paper in the cutting position, along entire length of bed, and make a cut.
2. If the shear does not cut the paper, loosen screw (L, Figure 8) at each end of table, with 8mm hex key.
3. Rotate adjustment screws (M, Figure 9) to shift table and change the gap between blades. **Do not allow the blades to overlap.**

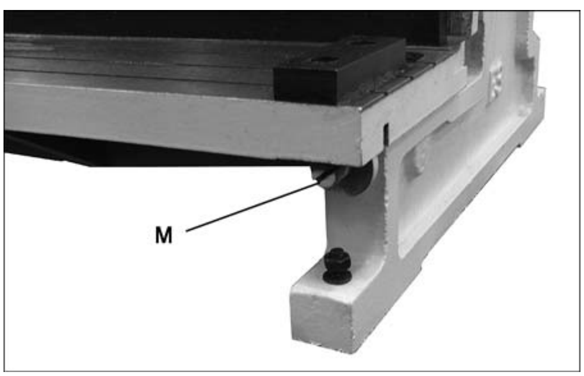


Figure 9

4. If the shear cuts the paper on the ends, but not the center, slightly turn screw (N, Figure 10) *clockwise* until paper is cut the entire length.
5. If the shear cuts the paper in the center, but not the ends, turn screw (N) *counterclockwise* until paper is cut the entire length.

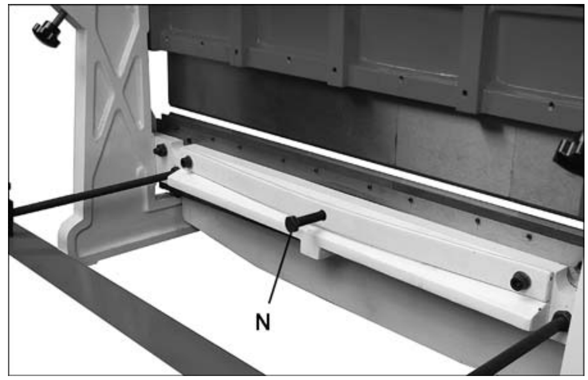


Figure 10

6.5.2 **Blade Rotation/Replacement**

⚠WARNING **Exercise caution when working with or near the blades. Use work gloves when handling them.**

The shearing blades are reversible and interchangeable; when the edges dull, rotate them to the new edge, as follows:

1. Remove *hold-down* by loosening *screws* (O, Figure 11), using 6mm hex key.
2. Raise *upper blade* to highest position.
3. Remove seven *screws* (P, Figure 11) and carefully remove blade.
4. Rotate or replace blade and re-install screws (P).
5. Reinstall hold-down. When blade is in highest position, the gap between the hold-down and the table should be within 1/4”. Adjust to this position by turning the two screws (O, Figure 11) as needed. When the blade starts its downward travel, the hold-down should immediately hold workpiece in place.

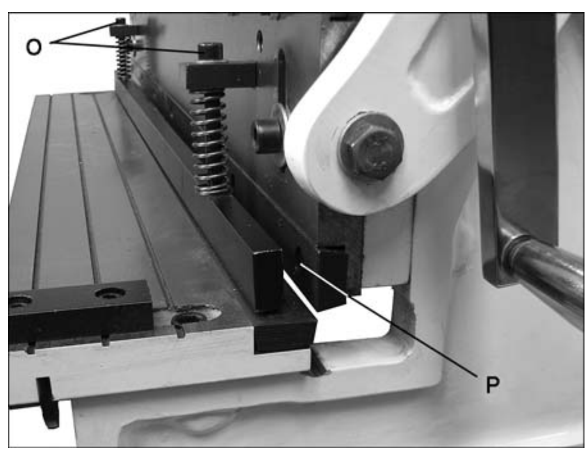


Figure 11

6.6 Slip Roll set-up

⚠WARNING Do not roll material larger than 30” (40”), 20-gauge mild steel. The slip roll guard must cover the rolls except when material is being fed into the rolls. Failure to comply may cause serious injury and/or damage to the machine.

Material Size Considerations

To determine approximate length of material needed for a desired size tube, use the following formula:

$C = \pi D$,
where C is the circumference,
π equals 3.1417
and D is the diameter.

For example: To find the length of material needed (*C*) to form a tube 4" in diameter, multiply 3.1417 by 4". Result: 12.5667" is the circumference of approximate length of material needed. Cut several pieces of material to this length for a forming test run. Material may have to be lengthened or shortened depending upon results of test run.

TIP: If it doesn’t interfere with the proposed final shape or design, a slight bend made with the press brake on the leading edge will simplify the initial rolling process, by allowing the leading edge to slip more easily over the idle roll.

⚠WARNING Beware of pinch point – the intersection of upper and lower rolls. Failure to comply may cause serious injury to fingers and/or hands.

1. Make sure rolls and workpiece are clean and free of debris to prevent pitting of sheet metal.
2. Back off idle roll completely by rotating *idle roll screws* (Q, Figure 12) counter-clockwise.

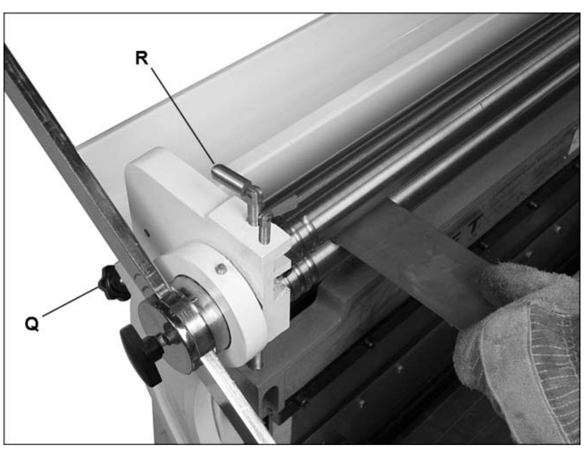


Figure 12

3. Loosen *bolt* (R, Figure 12) to increase space between upper and lower press rolls.
4. Insert material between upper and lower rolls, and tighten bolt (R, Figure 12) to lower the upper roll, until material fits snugly. The upper roll must have sufficient pressure on work piece to feed properly.
5. Rotate both *idle roll screws* (Q, Figure 12) to adjust idle roll’s proximity to the two main rollers. *Raise both ends an equal amount.*
6. Run workpiece through the machine using the handles. If workpiece is large, make sure it receives proper support as it exits the machine.
7. Make further passes of workpiece, raising the idle roll incrementally before each pass, until desired radius is achieved.

No exact formula can be followed when making roll adjustments because material “spring-back” varies with the kind of material being formed. Only by test forming several pieces can correct adjustments be obtained. Also, keep in mind that it is much easier to re-pass material to make a smaller radius than to attempt to increase a radius that was made too small.

The idle roll must be adjusted exactly parallel or the material will spiral during the rolling process. Measure each end of the opening with calipers if greater precision is required.

Deliberately setting the rolls non-parallel can be used to make cone shapes.

To remove cylindrical shaped workpieces:

1. Loosen *bolt* (R, Figure 13)
2. Loosen thumb screw (S) to release the roll catch.

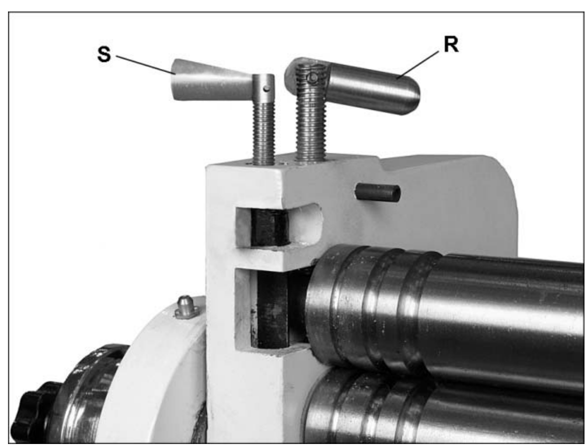


Figure 13

3. Carefully grasp upper roll and swing out the end.

CAUTION **Grasp upper roll firmly, to prevent it falling out of machine.**

4. Slip workpiece off end of roll.
5. Reinstall upper roll, and tighten screw and bolt (S, Figure 13).

6.6.1 Flat Rolling

Softer metals (copper, aluminum, etc.) can be processed through the slip roll machine to straighten, flatten, or reduce their thickness. Simply adjust the upper press roll for thickness, lower idle roll all the way down, and feed workpiece through (Figure 14).

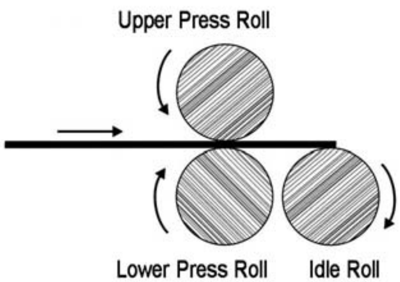


Figure 14

NOTE: The idle roll will not descend completely out of the path of the workpiece; thus, there may be a slight bend in the workpiece. By flipping the workpiece over and re-feeding it, this bend can be minimized.

6.6.2 Forming a Radius

1. Adjust upper press roll as needed.
2. Insert workpiece from front.
3. Operate handle; when the material reaches the point where the radius is to begin (a, Figure 15), stop the machine and raise the idle roll an equal amount on each end to achieve desired bend.

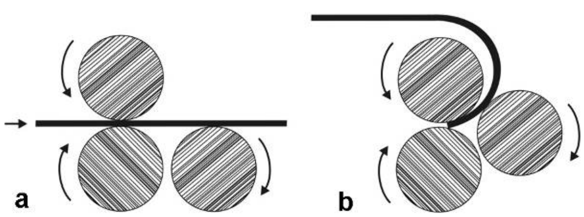


Figure 15

4. Restart rolls and continue until bend is completed (b, Figure 15). Support workpiece as it exits machine.
5. Make further passes if needed, along with incremental idle roll adjustments.

6.6.3 Forming a Tube

1. Adjust upper press roll as needed for workpiece thickness.
2. Feed workpiece into machine. As it nears the end (a, Figure 16), stop and reverse direction (b, Figure 16).
3. Make further passes if needed, along with incremental idle roll adjustments.

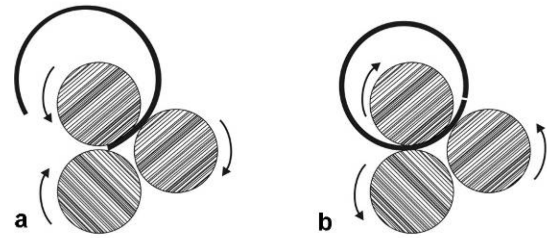


Figure 16

6.6.4 Bending Wire

There are three wire grooves at the end of the press rollers to accommodate a 1/8”, 3/16” and a 1/4” wire.

Use the smallest groove into which the wire will comfortably fit. Bend the wire using the same principles as described for forming a radius. To make a complete loop of wire, use the instructions for forming a tube.

7.0 Maintenance/Lubrication

⚠WARNING Use caution when doing maintenance work around the shear blades.

1. Apply #2 lithium tube grease once a month to the grease nipples on both ends of frame (A, Figure 17).
2. Keep the slip rolls clean and rust-free, and frequently apply a light coat of oil to them.
3. Lightly brush multi-purpose grease onto the gears at the end of the rollers (B, Figure 17). Turn operating handle to distribute the grease.
4. Keep other exposed areas clean and lightly coated with oil, such as the shear blades, table and upper dies. (Remove upper dies from bar for more effective cleaning).

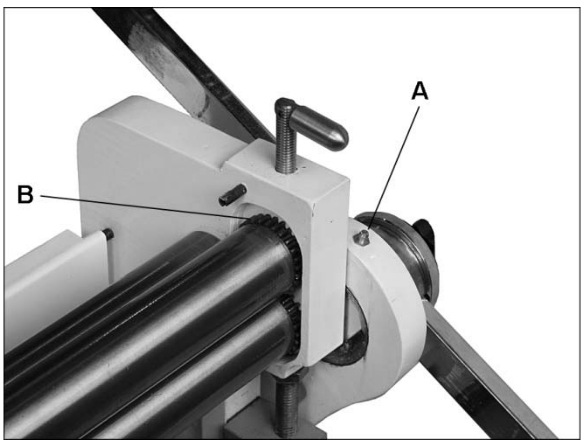


Figure 17

8.0 Optional Accessories

Part No.	Description
754030	Optional Stand for SBR-30N/M
754040	Optional Stand for SBR-40N/M



Figure 18 - Optional Stand

9.0 **Troubleshooting**

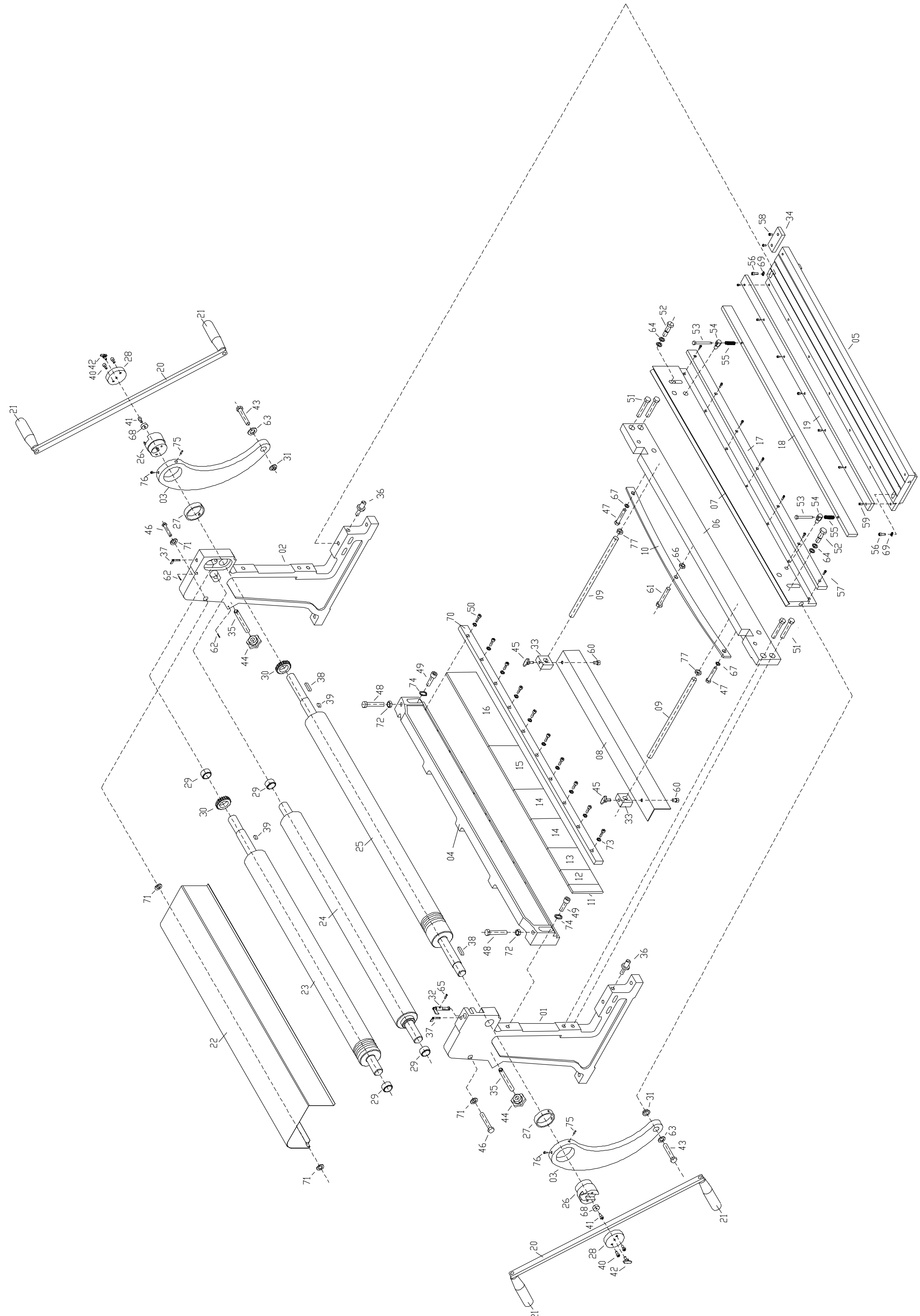
Trouble	Probable Cause	Remedy
SHEAR		
Material won't cut.	Incorrect blade gap.	Adjust gap to accommodate thicker material.
	Machine capacity exceeded.	Use materials within capacity.
Cuts not square.	Unequal blade gap.	Make blade gap equal.
	Not contacting table guides.	Maintain consistent guides contact.
	Blade is bowed.	Remove bow.
	Insufficient hold-down pressure.	Adjust hold down.
Poor cut quality.	Dull blade(s).	Replace or sharpen.
	Incorrect blade gap.	Adjust gap as needed.
	Loose gibs.	Adjust backlash out of gibs.
BRAKE		
Workpiece not bending, or bending difficult.	Workpiece too thick.	Use materials within capacity.
	Improper bend allowance.	Adjust brake beam for proper bend size.
Bend radius not consistent across material.	Machine capacity exceeded.	Use materials within capacity.
	Brake beam improperly set for bending allowance.	Adjust brake beam for consistent bend.
SLIP ROLL		
Cones are made when trying to roll cylinders.	Rolls not parallel.	Adjust idle (rear) roll until parallel to upper press roll.
Workpiece not bending.	Machine capacity exceeded.	Use materials within capacity.
	Idle roll not engaging.	Inspect and make corrections as needed.

10.0 **Replacement Parts**

Replacement parts are listed on the following pages. To order parts or reach our service department, call 1-800-274-6848, Monday through Friday (see our website for business hours, www.waltermeier.com). Having the Model Number and Serial Number of your machine available when you call will allow us to serve you quickly and accurately.

NOTE: Non-proprietary fasteners (part numbers beginning with TS-) are standard sizes, and can usually be found at local tool stores.

10.1.1 **SBR-30M Shear/Brake/Roll – Exploded View**

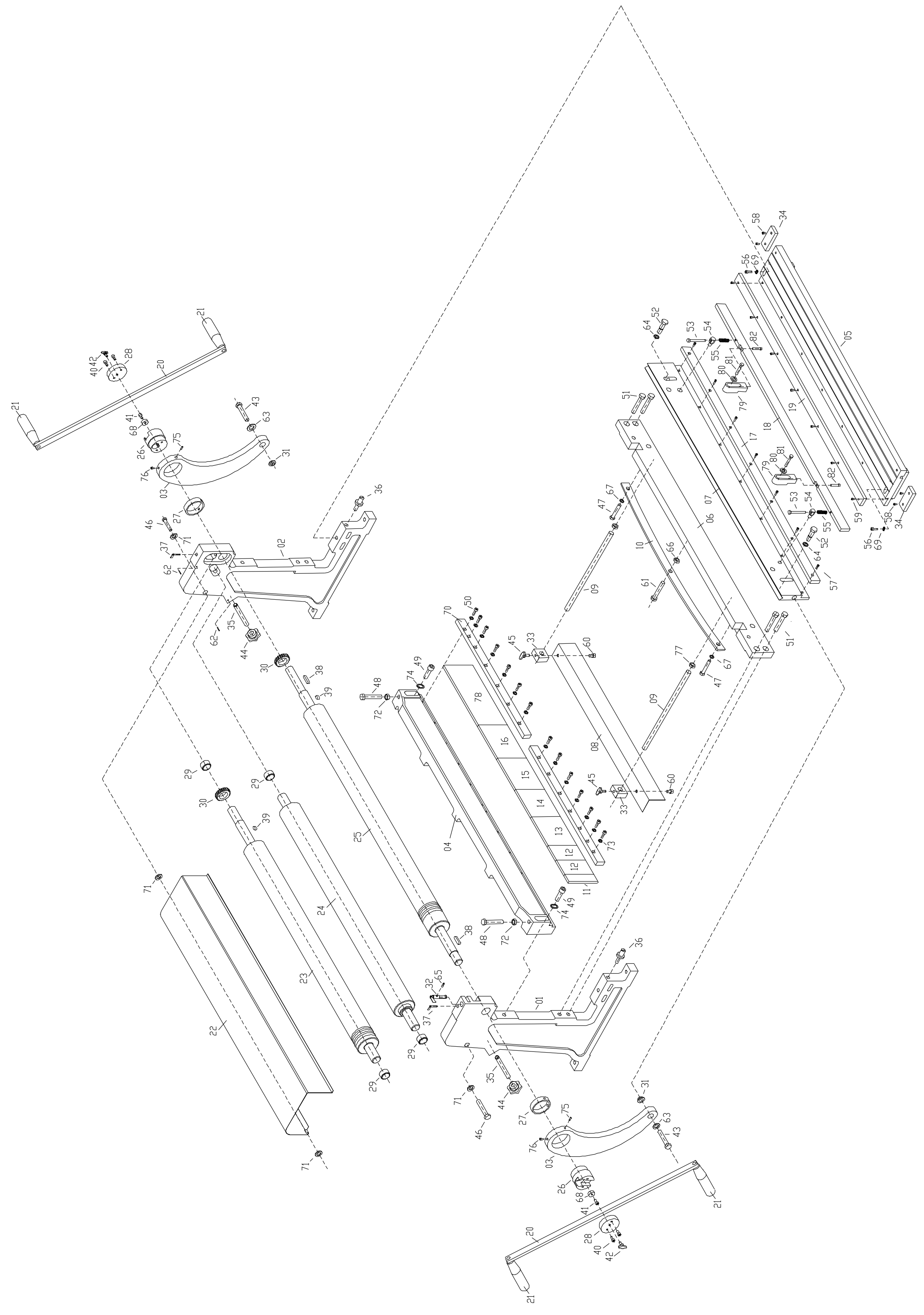


10.1.2 **SBR-30M Shear/Brake/Roll – Parts List**

Index No.	Part No.	Description	Size	Qty
01	SBR30M-01	Frame (left)		1
02	SBR30M-02	Frame (right)		1
03	SBR30M-03	Arm		2
04	SBR30M-04	Cross Beam		1
05	SBR30M-05	Table		1
06	SBR30M-06	Spacer Bar		1
07	SBR30M-07	Cutter Plate		1
08	SBR30M-08	Guide Plate		1
09	SBR30M-09	Guide Rod		2
10	SBR30M-10	Guide Bar		1
11	SBR30M-11	Brake Forming Die	1”	1
12	SBR30M-12	Brake Forming Die	2”	1
13	SBR30M-13	Brake Forming Die	3”	1
14	SBR30M-14	Brake Forming Die	4”	2
15	SBR30M-15	Brake Forming Die	6”	1
16	SBR30M-16	Brake Forming Die	10”	1
17	SBR30M-17	Cutter		1
18	SBR30M-18	Press Plate		1
19	SBR30M-19	Cutter		1
20	SBR30M-20	Handle Bar		2
21	SBR30M-21	Handle		4
22	SBR30M-22	Cover		1
23	SBR30M-23	Roll		1
24	SBR30M-24	Lower Press Roll		1
25	SBR30M-25	Upper Press Roll		1
26	SBR30M-26	Eccentric Shaft		2
27	SBR30M-27	Bushing		2
28	SBR30M-28	Eccentric Cap		2
29	SBR30M-29	Bushing		4
30	SBR30M-30	Gear		2
31	SBR30M-31	Pivot Bushing		2
32	SBR30M-32	Thumb Screw		1
33	SBR30M-33	Guide Block		2
34	SBR30M-34	Block		1
35	SBR30M-35	Screw		2
36	SBR30M-36	Locating Bolt		2
37	SBR30M-37	Adjustable Bolt		2
38	SBR30M-38	Key	8x7x25mm	2
39	SBR30M-39	Key	5x5x6mm	2
40	TS-1503031	Socket Head Cap Screw	M6x12	4
41	TS-1503031	Socket Head Cap Screw	M6x12	2
42	SBR30M-42	T-Handle	M8x25	2
43	SBR30M-43	Hex Cap Bolt	M12x70	2
44	SBR30M-44	Star Grip Knob	M10	2
45	SBR30M-42	T-Handle	M8x25	2
46	TS-1482081	Hex Cap Screw	M6x40	2
47	TS-1505021	Socket Head Cap Screw	M10x20	2
48	TS-2211451	Hex Cap Screw	M12x45	2
49	TS-1505051	Socket Head Cap Screw	M10x35	2
50	TS-1504051	Socket Head Cap Screw	M8x25	10
51	TS-1505041	Socket Head Cap Screw	M10x30	4
52	SBR30M-52	Screw		2
53	SBR30M-53	Hex Cap Bolt	M8x90	2
54	SBR30M-54	Pressure Plate Bracket		2
55	SBR30M-55	Spring		2
56	TS-1505031	Socket Head Cap Screw	M10x25	2

Index No.	Part No.	Description	Size	Qty
57	TS-1503031	Socket Head Cap Screw	M6x12	7
58	TS-1503031	Socket Head Cap Screw	M6x12	2
59	TS-1503031	Socket Head Cap Screw	M6x12	7
60	TS-1503031	Socket Head Cap Screw	M6x12	2
61	TS-1492051	Hex Cap Screw	M12x50	1
62	SBR30M-62	Spring Pin	5x20mm	4
63	SBR30M-63	Plain Washer	12mm	2
64	SBR30M-64	Plain Washer	8mm	4
65	TS-1523061	Hex Socket Set Screw	M6x20	1
66	SBR30M-66	Adjustable Nut	M12	1
67	TS-1550071	Plain Washer	10mm	2
68	SBR30M-68	Cover		2
69	SBR30M-69	Special Washer	10mm	2
70	SBR30M-70	Press Plate		1
71	TS-1550041	Plain Washer	6mm	4
72	SBR30M-72	Hex Thin Nut	M12	2
73	TS-1550061	Plain Washer	8mm	10
74	SBR30M-74	Special Washer	10mm	2
75	TS-1524051	Hex Socket Set Screw	M8x20	2
76	SBR30M-76	Zerk Fitting	8mm	2
77	TS-1540081	Hex Nut	12mm	2
	SBR30M-ID	I.D. Label (not shown)		1
	SBR30M-WL	Warning Label (not shown)		1

10.2.1 **SBR-40M Shear/Brake/Roll – Exploded View**



10.2.2 **SBR-40M Shear/Brake/Roll – Parts List**

Index No.	Part No.	Description	Size	Qty
01	SBR40M-01	Frame (left)		1
02	SBR40M-02	Frame (right)		1
03	SBR30M-03	Arm		2
04	SBR40M-04	Cross Beam		1
05	SBR40M-05	Table		1
06	SBR40M-06	Spacer Bar		1
07	SBR40M-07	Cutter Plate		1
08	SBR40M-08	Guide Plate		1
09	SBR40M-09	Guide Rod		1
10	SBR40M-10	Guide Bar		1
11	SBR30M-11	Brake Forming Die	1”	1
12	SBR30M-12	Brake Forming Die	2”	2
13	SBR30M-14	Brake Forming Die	4”	1
14	SBR30M-15	Brake Forming Die	6”	1
15	SBR40M-15	Brake Forming Die	7”	1
16	SBR40M-16	Brake Forming Die	8”	1
17	SBR40M-17	Cutter		1
18	SBR40M-18	Press Plate		1
19	SBR40M-19	Cutter		1
20	SBR40M-20	Handle Bar		2
21	SBR30M-21	Handle		4
22	SBR40M-22	Cover		1
23	SBR40M-23	Roll		1
24	SBR40M-24	Lower Press Roll		1
25	SBR40M-25	Upper Press Roll		1
26	SBR30M-26	Eccentric Shaft		2
27	SBR30M-27	Bushing		2
28	SBR30M-28	Eccentric Cap		2
29	SBR40M-29	Bushing		1
30	SBR40M-30	Gear		1
31	SBR30M-31	Pivot Bushing		2
32	SBR40M-32	Thumb Screw		1
33	SBR40M-33	Guide Block		2
34	SBR40M-34	Block		2
35	SBR40M-35	Screw		2
36	SBR40M-36	Locating Bolt		2
37	SBR30M-37	Adjustable Bolt		2
38	SBR40M-38	Key	8x7x25mm	2
39	SBR40M-39	Key	5x5x6mm	2
40	TS-1503031	Socket Head Cap Screw	M6x12	4
41	TS-1503031	Socket Head Cap Screw	M6x12	2
42	SBR30M-42	T-Handle	M8x25	2
43	SBR30M-43	Hex Cap Bolt	M12x70	2
44	SBR30M-44	Star Grip Knob	M10	2
45	SBR30M-42	T-Handle	M8x25	2
46	TS-1482081	Hex Cap Screw	M6x40	2
47	TS-1492021	Socket Head Cap Screw	M12x30	2
48	TS-2211451	Hex Cap Screw	M12x45	2
49	TS-1506051	Socket Head Cap Screw	M12x40	2
50	TS-1505051	Socket Head Cap Screw	M10x35	14
51	TS-1506041	Socket Head Cap Screw	M12x35	4
52	SBR40M-52	Screw		2
53	SBR30M-53	Hex Cap Bolt	M8x90	2
54	SBR40M-54	Pressure Plate Bracket		2
55	SBR40M-55	Spring		2
56	TS-1505031	Socket Head Cap Screw	M10x25	2

Index No.	Part No.	Description	Size	Qty
57	TS-1504021	Socket Head Cap Screw	M8x12	9
58	TS-1503031	Socket Head Cap Screw	M6x12	4
59	TS-1504021	Socket Head Cap Screw	M8x12	9
60	TS-1504021	Socket Head Cap Screw	M8x12	2
61	SBR40M-61	Hex Cap Bolt	M12x65	1
62	SBR30M-62	Spring Pin	5x20mm	4
63	SBR30M-63	Plain Washer	12mm	2
64	SBR40M-64	Plain Washer	12mm	2
65	TS-1524051	Hex Socket Set Screw	M8x20	1
66	SBR30M-66	Adjustment Nut	M12	1
67	TS-1550071	Plain Washer	10mm	2
68	SBR30M-68	Cover		2
69	SBR30M-69	Special Washer	10mm	2
70	SBR40M-70	Press Plate		2
71	TS-1550041	Plain Washer	6mm	4
72	SBR30M-72	Hex Thin Nut	M12	2
73	TS-1550071	Plain Washer	10mm	14
74	SBR40M-74	Special Washer	12mm	2
75	SBR30M-75	Hex Socket Set Screw	M8x20	2
76	SBR30M-76	Zerk Fitting	8mm	2
77	TS-154010	Hex Nut	M16	16
78	SBR40M-78	Brake Forming Die	12”	1
79	SBR40M-79	Press Plate Bracket		2
80	SBR40M-80	Plain Washer	12mm	2
81	SBR40M-81	Hex Cap Bolt	M12x45	2
82	TS-1503071	Socket Head Cap Screw	M6x30	2
	SBR40M-ID	I.D. Label (not shown)		1
	SBR30M-WL	Warning Label (not shown)		1

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